May-28-13 10:2		1024/2		*102	7472*						Page 1
Item ID: Revision ID: Item Name:	D3917-3 Washer		,	Accept	*N900	040	100)* s	etup Stai	I	S1*
Start Date: Required Date: Reference:	5/22/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:	,				
Approvals:		Plan: MLJ	Date: /3-05-28			nte:		R	tun Stai Sto	171	R1*
Sequence ID/ Work Center II		Operation Description	Date:	SPC (Y/N): Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	R2* Insp. Stamp
Draw Nbr		Revision Nbr									
D3917	А	\									DAs-
*100 *100* Hardinge Hardinge CNC Lath	ne Small	Memo	PER 50/10 -FA876 & DWG	0.00	Ţ.	3.6-2		40	4		04
Traidinge CNC Lati	ic Sinaii	FOLIO RE' DWG REV	V: 47								
110		DEBURR QC2- Inspect parts off n	nachine FAI/FAIB	0.00	13	- (, -2		10	ند		DAS 04
110 QC Quality Control		Memo		0.00		10 E-		40	9		<u>5-89</u>

DQA:		Date:										™DΔRT
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UF		Nork Order u	ndate only - [AEROSPACE
					DISDOSITION		ĺ			•		<u> </u>
Work Orde	er:				DISPOSITION				AGAINST	DEPARTMENT	/PROCESS	
					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo				Scrap	:		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		-			Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No				Suspected Unapproved			Large Fab	Composite		Supplier[
Root				Desci	ription of work order update		Initial	Acti	on	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Design		1							-	"		
Doc/Data												
Equip/Tooling												
Handling/Pre		ļ										
Material												
Operator												
Offset/Setup 1												
Process												
Supplier												
Training		}									·	
ransport												
Jnapproved										. [
						FAI	ULT CAT	TEGORY				
Landir	ng Gear				General		_					
	Bending				Bend		Folio/P	rogram		Outside Dim	nensions	Pressure/Forced
	Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re	[Part Incorre	ct	Temperature/Cure
	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Un	qualified	Part Lost/M	issing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	
	Heat Trea	at			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
	Inspectio	n Strip in	Tube		Drawing		Misread	i	_			
	Marks/Ch	natter			Drill Holes		Off-set					
	Turning S	equence			Finish		Out of 0	Calibration				
	Wave/Tw	ist in Tub	oe		Fit/Function		Out of S	Sequence				

Quality Control

May-28-13 10.		02412			~1(1)	7477"							Pag	e 2
Item ID: Revision ID:	D3917-3			A	ccept	*N900	040	100)* s	Setup	Start	*N:	S1 *	.
Item Name:	Washer										Stop	*N!	S2*	F
Start Date:	5/22/13	Start Qty: 40.00		*40*		Cust Item I	D:							
Required Date Reference:	e: 5/27/13	Req'd Qty: 40.00		*40*		Customer:		. •						•
Approvals:	Process P	lan:	Date:		Tooling:	D:	ate:		F	Run	Start	*NI	R1*	Ė
	QC:		_ Date:_		SPC (Y/N):	D a	ate:				Stop	*N	R2*	Ė
Sequence ID/ Work Center	ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp)
*120 *120*		QC8- Inspect parts - seco	ond check		0.00	A 13-	06-03		40		0			
QC Quality Control		Memo			0.00									
130		ldentify as per dwg & St	ock Location	8007	λ · 0.00							·		
130 Packaging Packaging		Memo			0.00		·		40x	<u> </u>		(<u> </u>	Q-
140		QC21- Final Inspection	- Work Order	Release	0.00									
*14 ∩ *		Memo			0.00					1C 2	73	<u>-06-</u>	05	

& Bolis

DQA:		Date:										DAF	T
		.			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	,			AEROSE	ACE
QA Closed:	 	Date:							W	ork Order up	odate only		
Work Orde	er:				DISPOSITION			AGAI	IST DE	EPARTMENT,	/PROCESS		
					Rework	1		Skid-tube Crosstu	ıbe		Water Jet	Engineering	
Part N	No.				Scrap			Machining Small I	_	Pro	d. Eng. Coor.	Quality	_
					Use-as-is		3	noforming Finish	ing	-	re/Packaging	Other	\vdash
NCR I	No				Suspected Unapproved			Large Fab Compos			Supplier		
			· , ,										
Root				Desci	ription of work order update	1	Initial	- Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspect	tor
Design													
Doc/Data													
Equip/Tooling	Н					1							
Handling/Pre	Щ												
Material	H	:	1										
Operator	H												
Offset/Setup	H												
Process	\vdash												
Supplier	H												
Training Transport	\vdash										·	1	
Unapproved													
опаррточеа	L	<u>l</u>	.11			FΔI	UT CAT	TEGORY					
Landii	ng Gear		<u>_</u>		General	17	OLI CA	i Looki			· ·		-
	Bendir	ıg			Bend		Folio/P	Program		Outside Dim	ensions [Pressure/Forced	d
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	ļ	Set-up	. !
	Cracks				Broken/Damage/Defect	\vdash	Hardwa	are		Part Incorred	_	Temperature/Co	ure
	Crimp	Kink/Ripple	e/Wave		Burrs		1	ion Incomplete/Unqualified		Part Lost/Mi	 -	Weld	
	Cuffs				Contamination		1 '	ions Incomplete/Unclear		Part Moved	ř	Wrong Stock Pu	lled
	Crushi	ng			Countersink	$\overline{}$	1	ned/off center		Positioned W	∟ ⁄rong		
	Heat T	reat			Cut Too Short		Mislabe			Power Loss/S		Other	
	Inspec	tion Strip in	Tube		Drawing		Misread	.	_	· ·			
	Marks	'Chatter			Drill Holes		Off-set						
	Turnin	g Sequence			Finish		Out of 0	Calibration					
	Wave/	Twist in Tub	be		Fit/Function		Out of 9	Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

May-28-13 10:21:22 AM

Work Order ID:

102472

Parent Item:

D3917-3

Parent Item Name:

Washer

Start Date: 5/22/13

Required Date: 5/27/13

Start Qty: 40.00

Required Qty: 40.00

13.6.2

Comments:

Ipp Rev:A New Issue 09-12-02 JLM Verified by:DD 10.02.22 verified by:EC

IPP Rev:B as per dwg REV.A DD

40

101.153

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750 Delrin Round Bar 0.75"		Purchased	No			100	f	179.0480	0.02	0.842104		· · · · · · · · · · · · · · · · · · ·	
				Location		Loc Qty	<u>L</u> c	c Code					
				MAT018		179.048							
				11618	33	4.8			- <u></u>				,
				11727	73	4.665							
				11732	22	0.94							
				12178	33	27.49							~^'0

124957

DQA:		_ Date:										
					WORK ORDER NON	-C(ONFO	RMANCE / UPDATE			_	AEROSPACE
QA Closed:		Date:					, <u>.</u>		W	ork Order u	odate only	
Work Orde	r:				DISPOSITION			AGAINST	r DE	PARTMENT	/PROCESS	
					Rework	7		Skid-tube Crosstube	,	1	Water Jet	Engineering
Part N	0.				Scrap	1		Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
	<u></u>	-		-	Use-as-is	1	1	noforming Finishing		4	re/Packaging	Other
NCR N	O				Suspected Unapproved	1 :	:	Large Fab Composite			Supplier	1
Root				Desci	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data											-	
Equip/Tooling	_											,
Handling/Pre	_											
Material	_											
Operator	_											
Offset/Setup	_											
Process	4											
Supplier	_					İ						
Training	_											
Transport	_							,				
Unapproved						<u> </u>						
						FA	ULT CAT	regory				
Landin [General	_]		_	1		7
}-	Bending	- • C			Bend BOAA/Rawta	-	1	rogram	-	Outside Dim		Pressure/Forced
/ 	Cracks	ot Concer	ntric	_	BOM/Route	<u> </u>	Grain		_	Over/Under	 	Set-up
<u> </u>		nk/Ripple	Alaua	_	Broken/Damage/Defect	\vdash	Hardwa		-	Part Incorred	 	Temperature/Cure
` -	Cuffs	пкукірріе	y vvave	_	Burrs	-	1	on Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	Weld
F	Crushing			-	Contamination	\vdash	1	ions Incomplete/Unclear	<u></u>	Part Moved	_	Wrong Stock Pulled
-	Heat Trea				Countersink Cut Too Short	-	Mislabe	ned/off center	-	Positioned W	· —	ا
· -	Inspectio		Tubo	-	Drawing	-	ł		L	Power Loss/S	surge	Other
-	Marks/Ch		TUDE	-	Drill Holes	-	Misread Off-set	1				
	Turning S				Finish	 		Calibration				
<u> </u>	Wave/Tw)e		Fit/Function	<u> </u>	4	Seguence				

DART AEROSPACE LTD	Work Order:	102472
Description: Washer	Part Number:	D3917-3
Inspection Dwg: D3917 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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		Installe		FIOLO	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
Ø0.65	+/-0.030	151			29.02		
0.06	+0.000/-0.020	.050	/	_	1,00		
Ø0.257	+0.006/-0.001	.257			λ(
~~	10.000, 0.001				N'		

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		<u> </u>					
					<u> </u>	·	
	I, DAG						
leasured by:		Audited by:	SS		Prototype App	oroval:	N/A
Date:	3.1-2	Date:	13-06-0	03	12	Date:	N/A
lev Date (Change				Revised	d bw /	Apprøve
	Vew Issue				KJ	3	7///

